

Work Order ID 73311

Wednesday, August 31, 2011 10:49:14 AM

Page 1

Item ID: D3535-35

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 9/1/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: MLF

Date: 11-09-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

364 . 040

B11-9-14



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suborly

counts
x26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73311

Wednesday, August 31, 2011 10:49:15 AM



Page 2

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Brake NC

Memo

0.00

1-Deburr if necessary □ 2-Form on Brake as per Dwg D3535 using Jigs
DT8261 and DT8326. □ 3-Identify as D3535-35.

SB 11/6/19

26

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

8/11/19

counts

26

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powder Coating

Memo

0.00

START TIME: 2:15 □ OVEN TEMPERATURE:

□ FINISH TIME:

320°F

2:45

26x4 M-11/09/20

M117338

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Picklist Print

Wednesday, August 31, 2011 10:49:11 AM

Page 1

Work Order ID: 73311

Parent Item: D3535-35

Parent Item Name: Wearshoe



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

212.4072

0.8022

16.88842

21.



304/316 .040 Sheet



B11-9-14

Location

Loc Qty

Loc Code

MAT020

212.4072

116623

0.2

117550

9.363

117933

79.3442

118400

123.5

117933

26

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DART AEROSPACE LTD		Work Order:	72711
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	2		V H302	
1.885	+/-0.010	1.884	2		V	
6.00	+/-0.030	6.00	1		T H301	
6.75	+/-0.030	6.75	3		T	
Ø0.188	+0.005/-0.001	.192	2		V	
23.250	+/-0.010	23.250	0		T	
19.750	+/-0.010	19.750	2		T	
17.750	+/-0.010	17.750	1		T	
14.250	+/-0.010	14.250	2		T	
9.500	+/-0.010	9.500	2		T	
4.750	+/-0.010	4.750	2		T	
0.300	+/-0.010	.304	2		V	
0.300	+/-0.010	.306	1		V	
0.038	+/-0.010	.034	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-9-14	Date: 11/09/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

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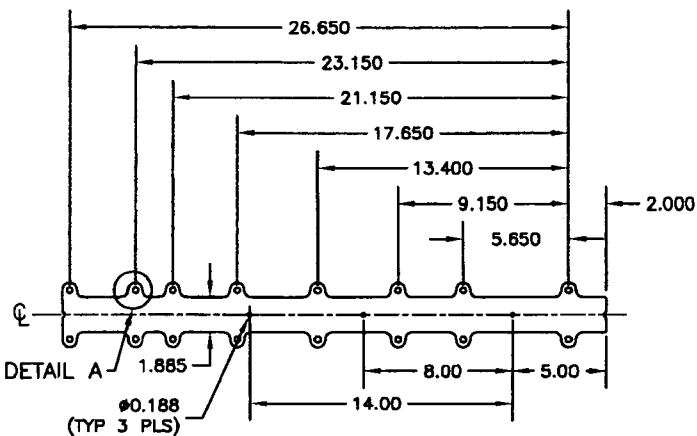
NOTE: Date & initial all entries

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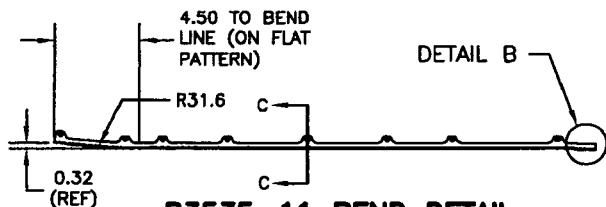
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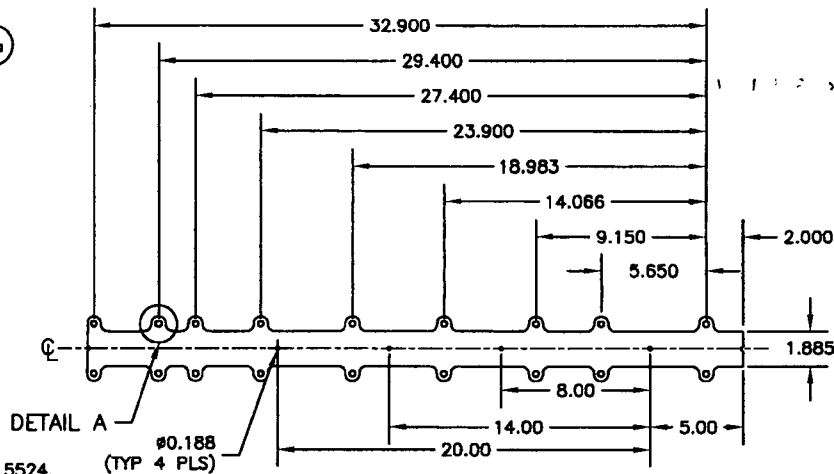
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CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	



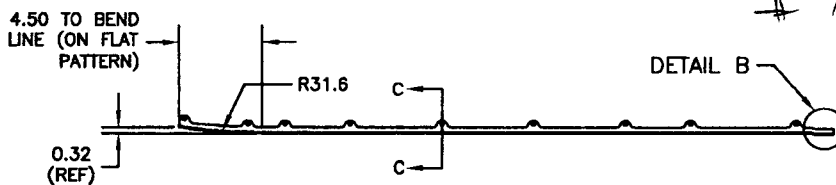
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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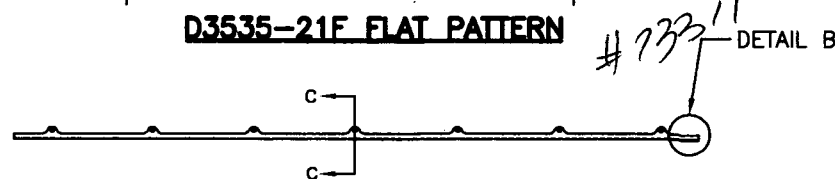
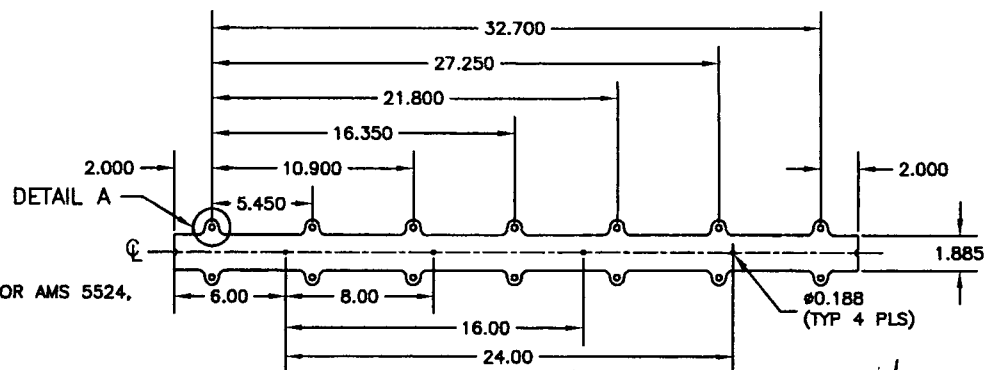
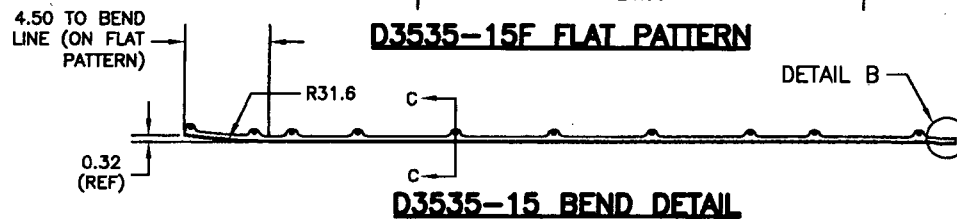
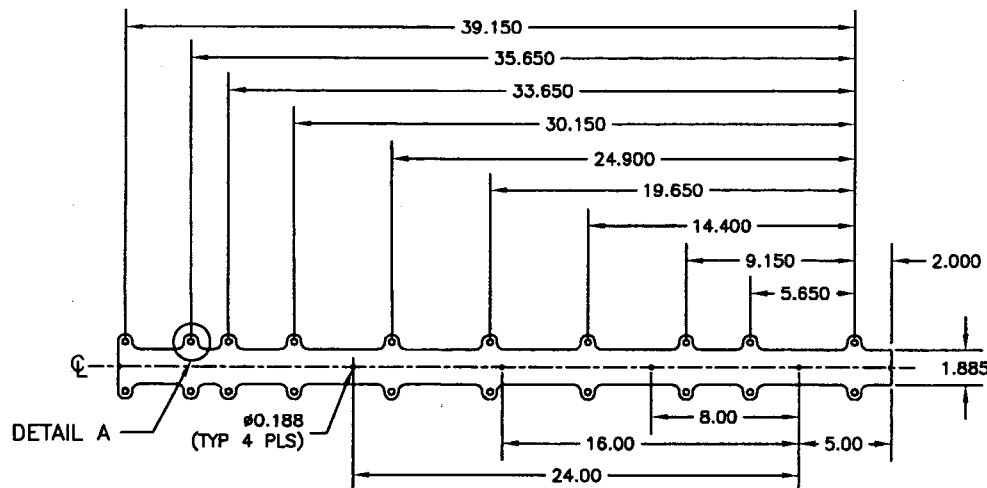
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07.04.24 #

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#	#	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 2 OF 7
		REV. B

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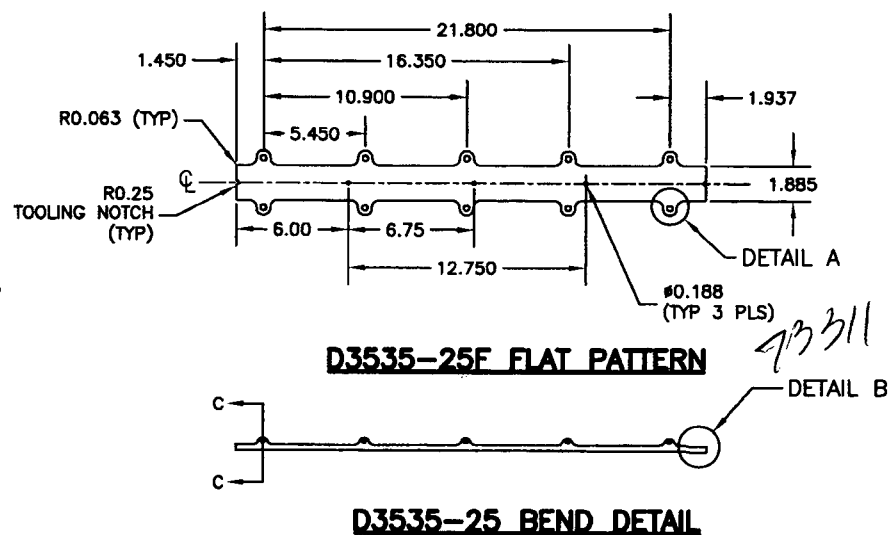
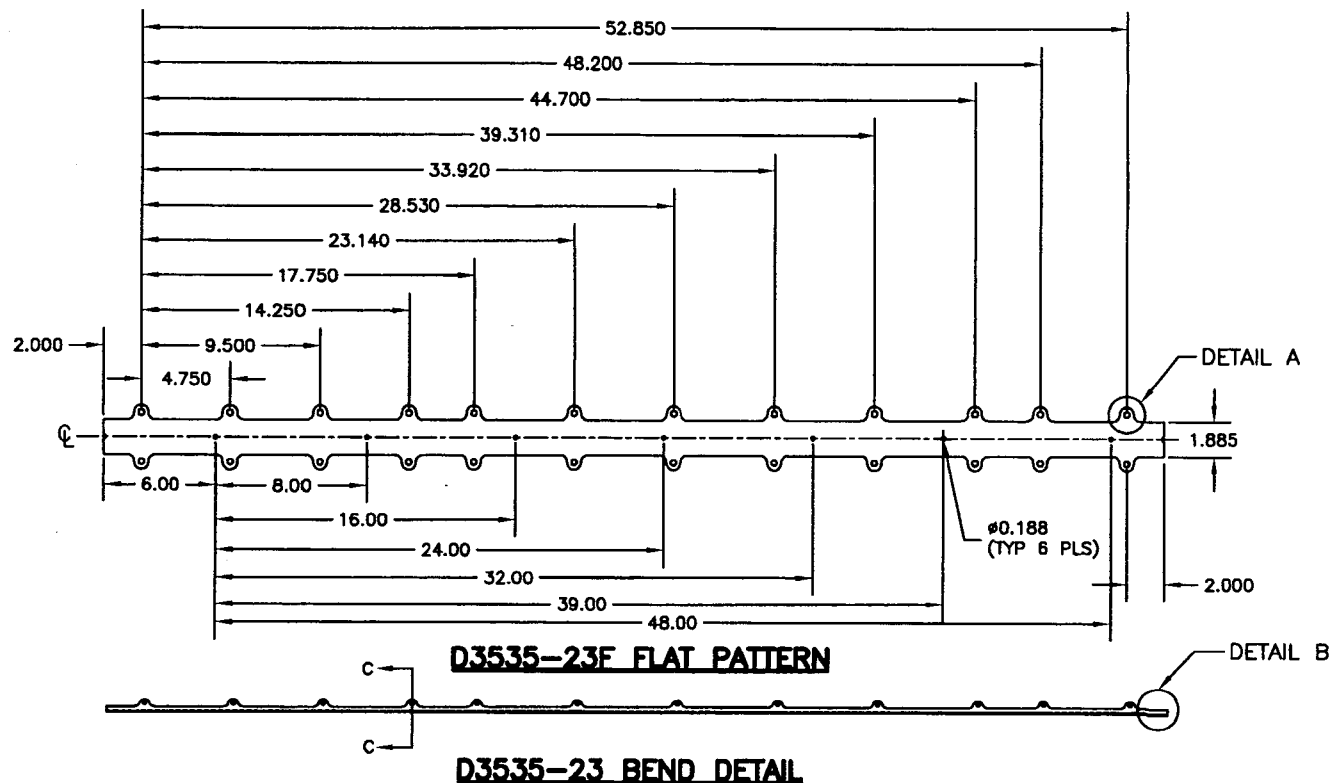
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DATE 07.04.17	TITLE D3535	DRAWING NO.
	WEARSHOE	SHEET 3 OF 7
		REV. B
		SCALE 1:10

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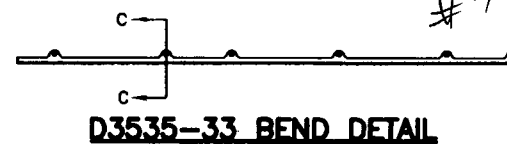
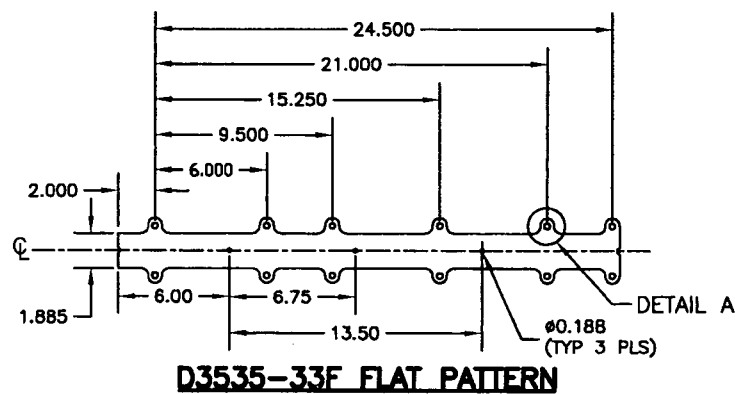
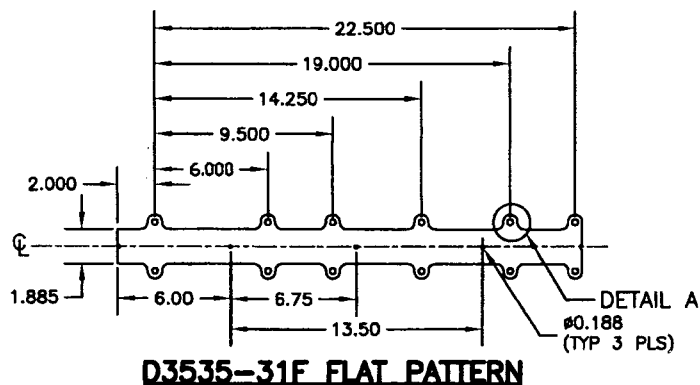
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		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

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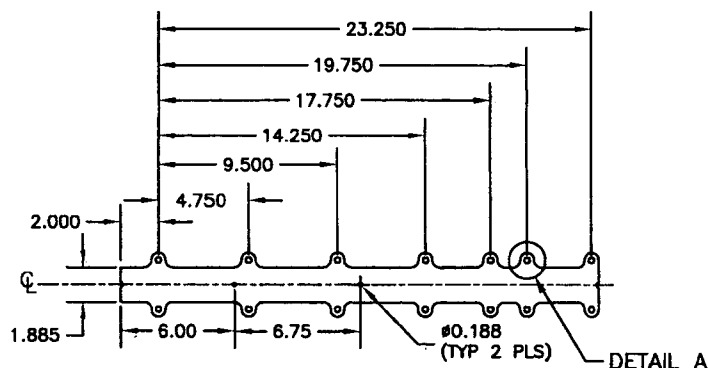
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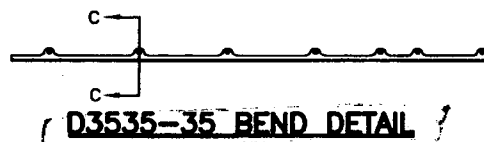
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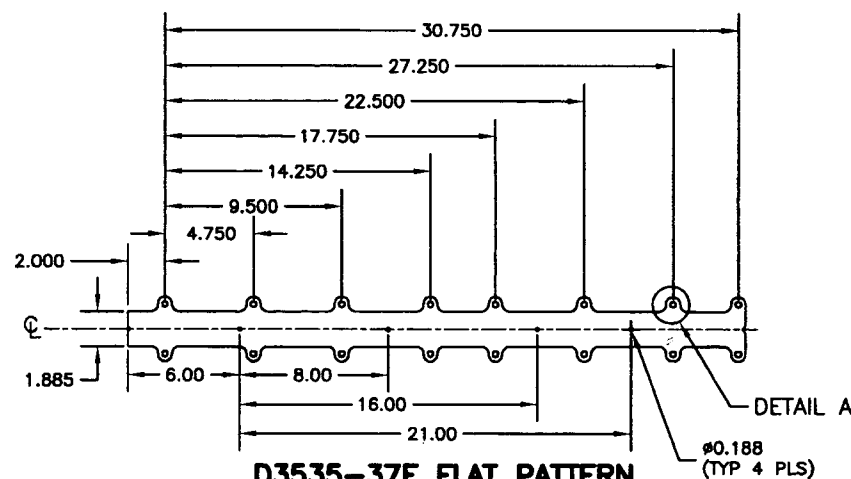
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
				SCALE
				1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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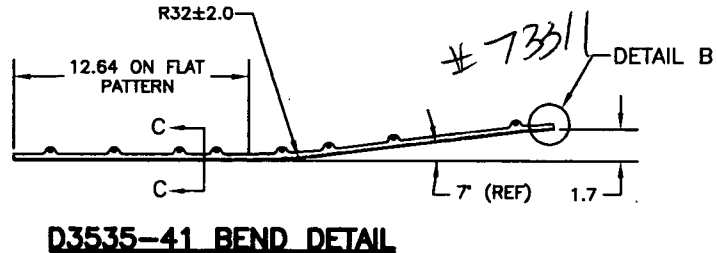
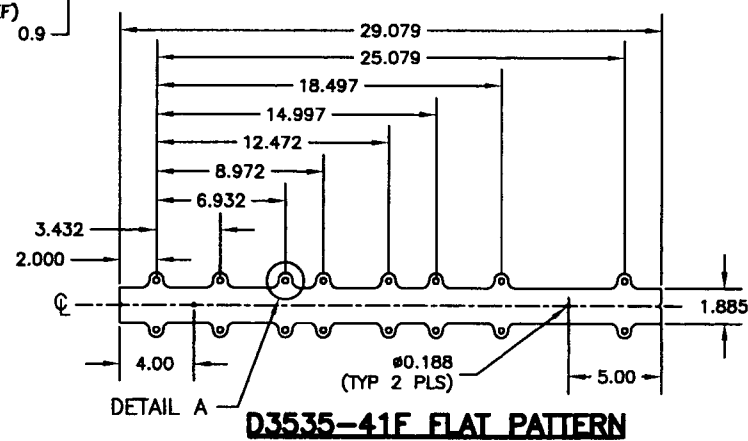
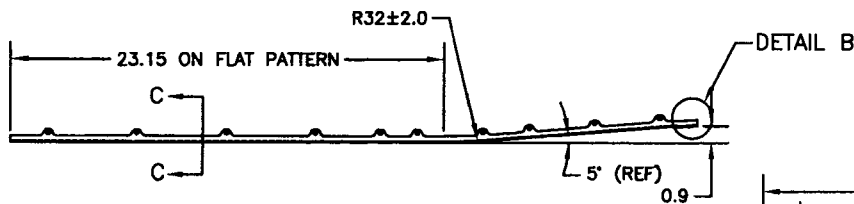
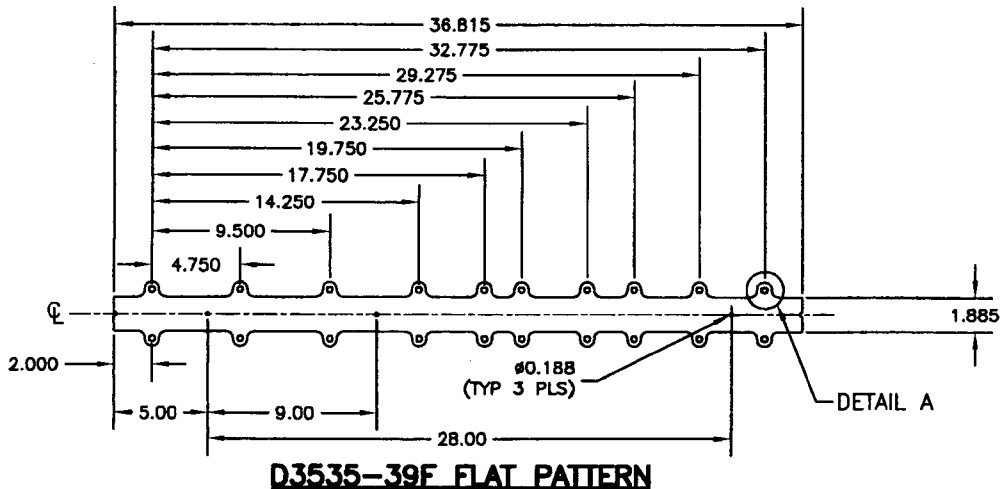
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DATE	TITLE	SCALE	
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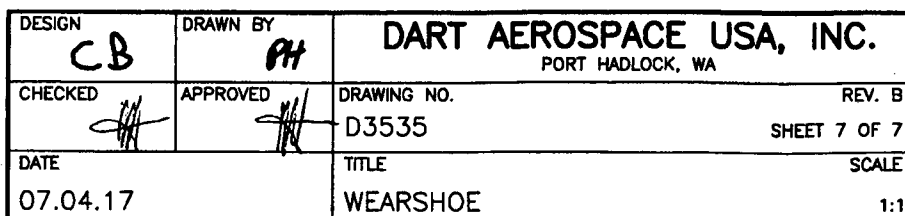
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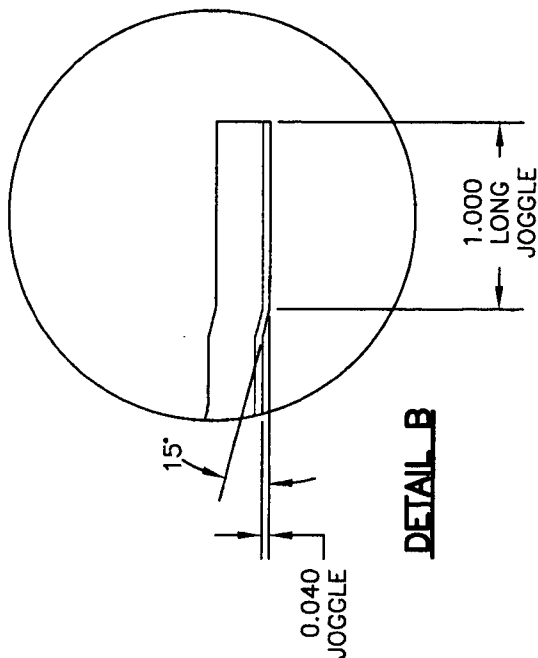
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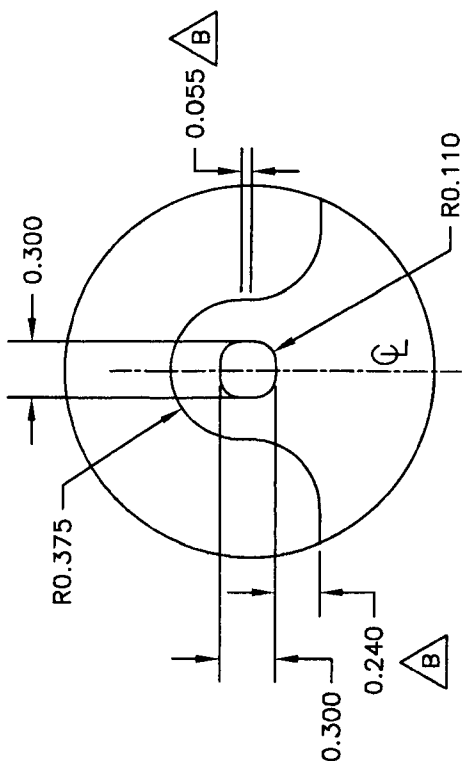
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07-04-24

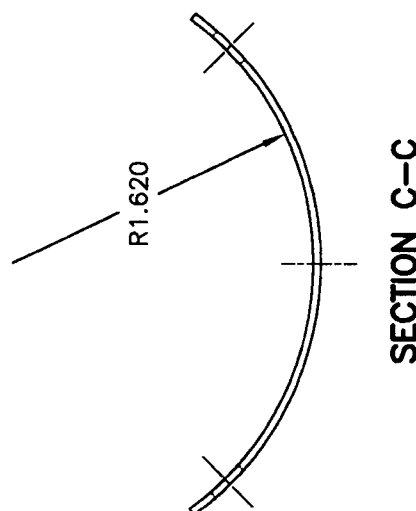


DETAIL B

#7331



DETAIL A



SECTION C-C

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